

Work Order ID 73921

Monday, September 19, 2011 11:37:01 AM

**PRELIMINARY ISSUE**

Page 1

Item ID: D3805-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 9/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: W

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3805	PB1 <u>11.09.19</u> B <u>11.10.04</u> <u>92W11-640</u>	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3805 Dwg Rev: <u>PB1</u> Prog Rev: <u>PB1</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

B119-19D119-19

Work Order ID 73921

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Page 2

Item ID: D3805-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Plate

Start Date: 9/19/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 9/20/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00 - inspection to PB1



QC

Memo

0.00 Dry only
8/19/19 (7C)

Quality Control

130

0.00



Brake NC

Memo

0.00 SB 11/09/20

Brake NC

Form as per Dwg D3805 using Jigs DT8261 and DT8326

140

QC5- Inspect part completeness to step on W/O

0.00 - inspection sample



QC

Memo

0.00 SKID. Fit is AOK

Quality Control

8/11/20 to PB1 Dry only (40)

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Item ID: D3805-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 9/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: W/A

0.00



Packaging

Memo

73939

0.00

Packaging

D3805-1

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11-10-3

11/10/4

POSITIVE RECALL
EFFECTIVE: 11/19/11 AUTH: u
RELEASED: 11/19/11 DATE: 11/10/11
ECW 11-640

11-10-03

Picklist Print

Monday, September 19, 2011 11:36:58 AM

Page 1

Work Order ID: 73921

Parent Item: D3805-1

Parent Item Name: Plate



Start Date: 9/19/2011

Required Date: 9/20/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-07-15 new issue DD verified by:EC
IPP Rev:B 08-07-30 redesign flat pattern DD verified by:EC
IPP Rev:C 08-09-23 redesign flat pattern DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S18GA

Purchased

No

100

sf

211.1550

3.8542

4.057053



B119-19

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT020

64.655

113062

0.155

116979

64.5

MAT021

146.5

118217

146.5

118217


DART AEROSPACE LTD		Work Order: 73921
Description: PLME		Part Number: D 3805-1
Inspection Dwg: D3805-1, Rev: PB1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

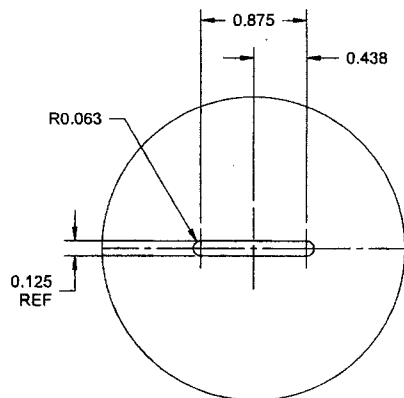
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.400	$\pm .010$.401	X		V RB02	
.125	$\pm .010$.127	X		V	
.875	$\pm .010$.875	X		V	
.938	$\pm .010$.938	X		V	
5.420	$\pm .010$	5.417	X		V	
3.00	$\pm .030$	3.005	X		V	
.250	$\pm .010$.253	X		V	
1.25	$\pm .030$	1.260	X		V	
.063	$\pm .010$.064	X		V	
Ø .188	$\pm .005$ - .001	.191	X		V	
7.000	$\pm .010$	7.000	L		T RB01	
24.000	$\pm .010$	24.000	X		T	
4.500	$\pm .010$	4.500	L		V	
5.320	$\pm .010$	5.315	X		V	
4.000	$\pm .010$	4.002	X		V	
3.000	$\pm .010$	3.003	X		V	
15.450	$\pm .010$	15.450	L		T	
33.175	$\pm .010$	33.175	X		T	
42.073	$\pm .010$	42.073	L		T	
43.25	$\pm .030$	43.25	X		T	
.050	$\pm .010$.047	X		V	

Measured by: RB
Date: 11-9-19

Audited by: 
Date: 11/09/19

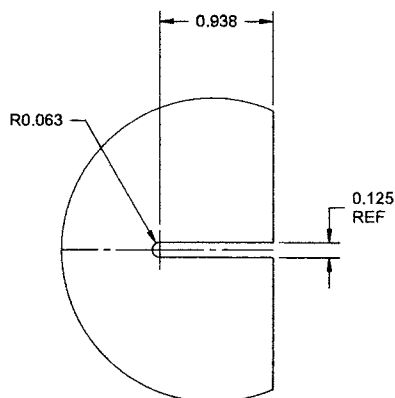
Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



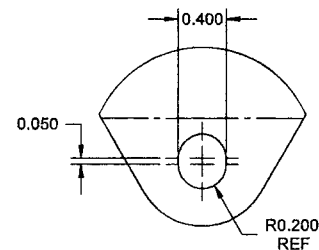
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SLOT DETAIL TYP
SCALE 4X

C5-4
C5-5
C4-6
C4-7



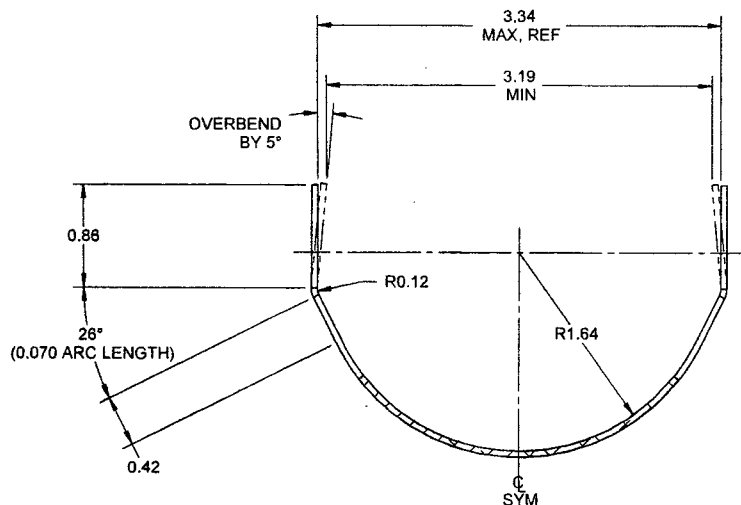
DETAIL G
SLOT DETAIL TYP
SCALE 4X

C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X

B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X

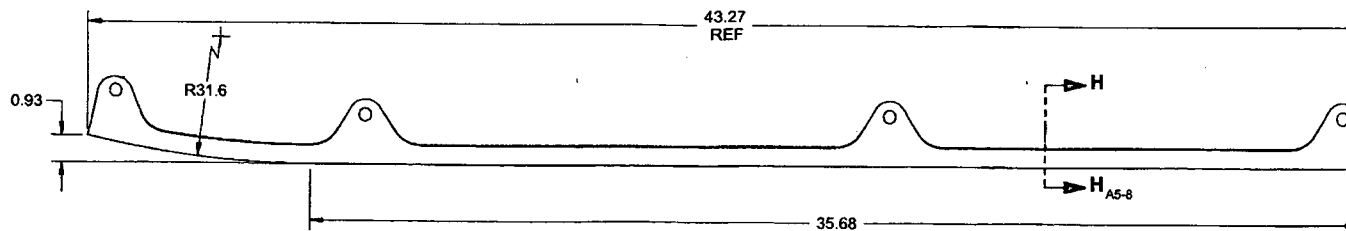
D3-4
D3-5
D3-6
D3-7

PRELIMINARY ISSUE

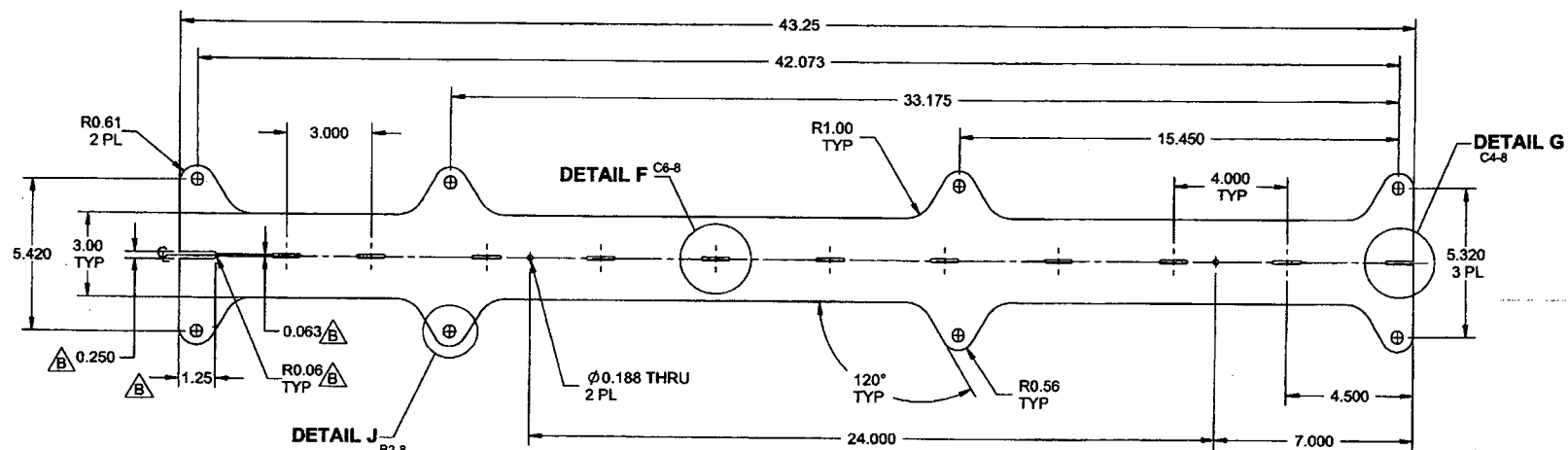
11.09.16

DESIGN	90	DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		D3805	SHEET 8 OF 8
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8 7 6 5 4 3 2 1



D3805-1 PLATE
(MAKE FROM D3805-1F)



D3805-1F PLATE

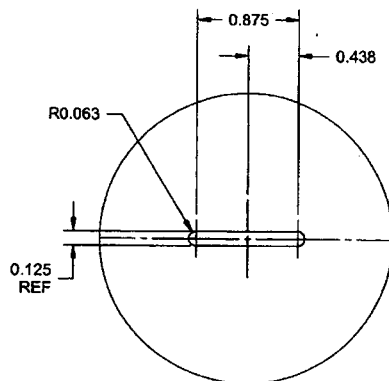
RELEASED
R 2011-10-03
JH

NOTES:

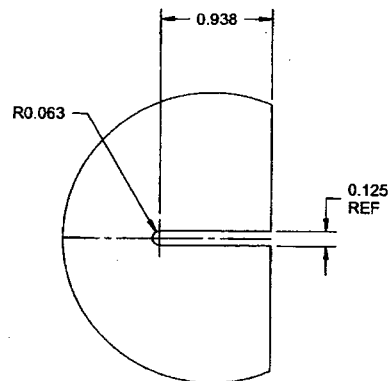
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.11 lbs

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MFG. APPR.		D3805	SHEET 4 OF 8
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DE APPR.		WEARPLATE ASSY	NTS
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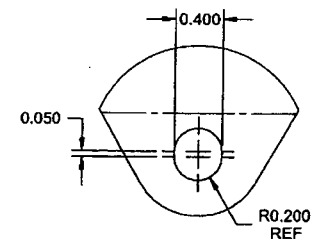
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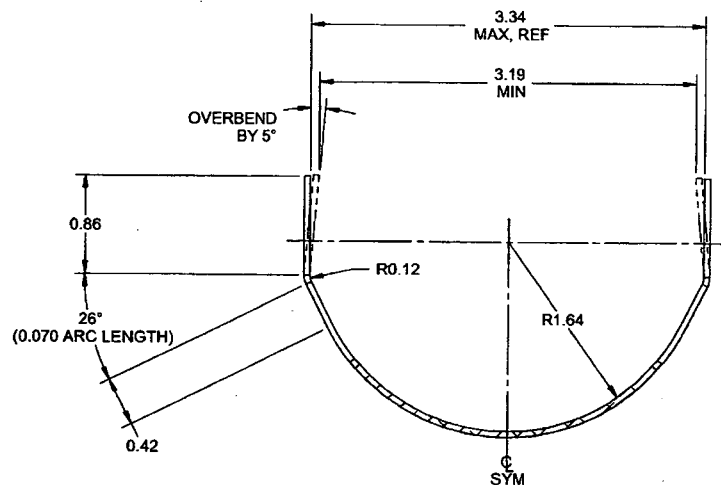
DETAIL F
SLOT DETAIL TYP
SCALE 4X
C5-4
C5-5
C4-6
C4-7



DETAIL G
SLOT DETAIL TYP
SCALE 4X
C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X
B8-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X
D3-4
D3-5
D3-6
D3-7

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2011-10-03

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MFG. APPR.		SHEET 8 OF 8
APPROVED		TITLE WEARPLATE ASSY SCALE NTS
DE APPR.		
DATE	11.09.16	

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